

Date: Thursday, 20/11/2008 3:34:34 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WINDOW ASSEMBLY		
Job Number	: 43605			Part Number	: D3136043		
Estimate Number	: 10304			Drawing Number	: D3136 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 20/11/2008	S.O. No.	:	Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 20/12/2008		
Previous Run	: 35458B			Qty:	10	Um:	Each
Written By	:						
Checked & Approved By	: <u>JL 08.11.21</u>						
Comment	: Est Rev:A 04.02.04 New issue KJ/DS Est Rev.B 07.05.29 Thermoform in-house DL Est rev C 07.09.28 Rev E dwg EC verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MACRLICS125	1/8" Polycast II Sheet 109 570 18 8-11-26
2.0	WATER JET	FLOW WATER JET E E 18 8-11-26
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 18 8-11-26
4.0	QC8	SECOND CHECK S 0814626 410
5.0	THERMOFORMING	THERMOFORMING MACHINE X 10
Comment: 1-Thermoform as per Dwg D3136 and Folio FTA002 Dwg Rev. <u>E</u> Folio Rev. <u>A</u> . 2- Engrave Part # and Batch # , and affix labels (D3136-3) <u>DL 09/12/15</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WINDOW ASSEMBLY

Job Number: 43605

Part Number: D3136043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/12/15

X10

Check product for scratches mal-formation or any other non conformances.

7.0 QC8

SECOND CHECK



Comment: SECOND CHECK

BB 08/12/15 X10

8.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches as required

BB 08/12/15 X10

9.0 D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part# Description Batch 734554 X10
2 D3108-9 Decal

BB 08/12/15 X10

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15 X10

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST216

BB 08/12/16 X10

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16 X10

Job Completion



W.D. 12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43605
Description: Window Assembly	Part Number:	D3136-043
Inspection Dwg: D3136	Rev: E	Page 1 of 1

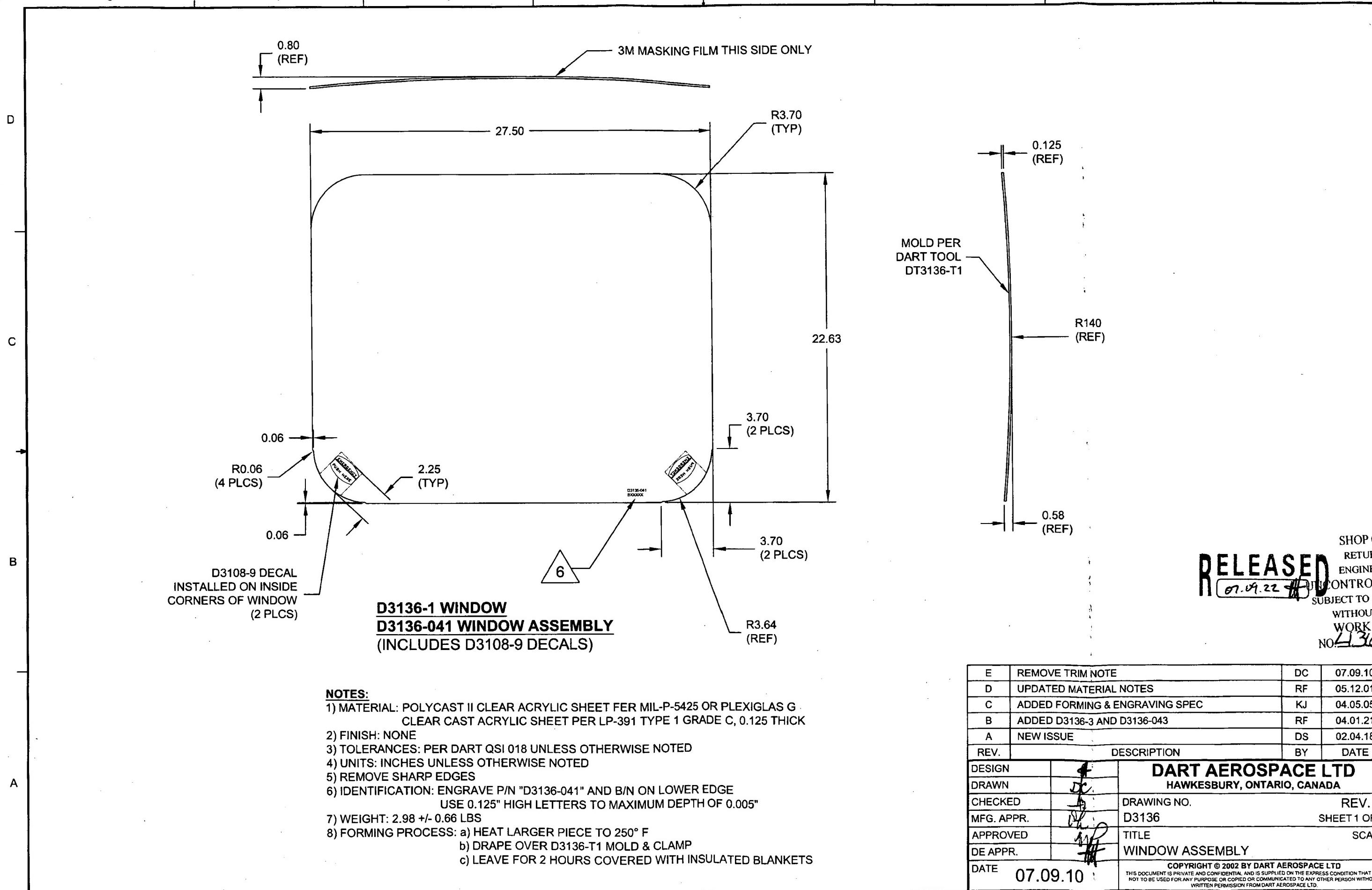
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	8-11-76	Date:	05/11/76	Date:	N/A

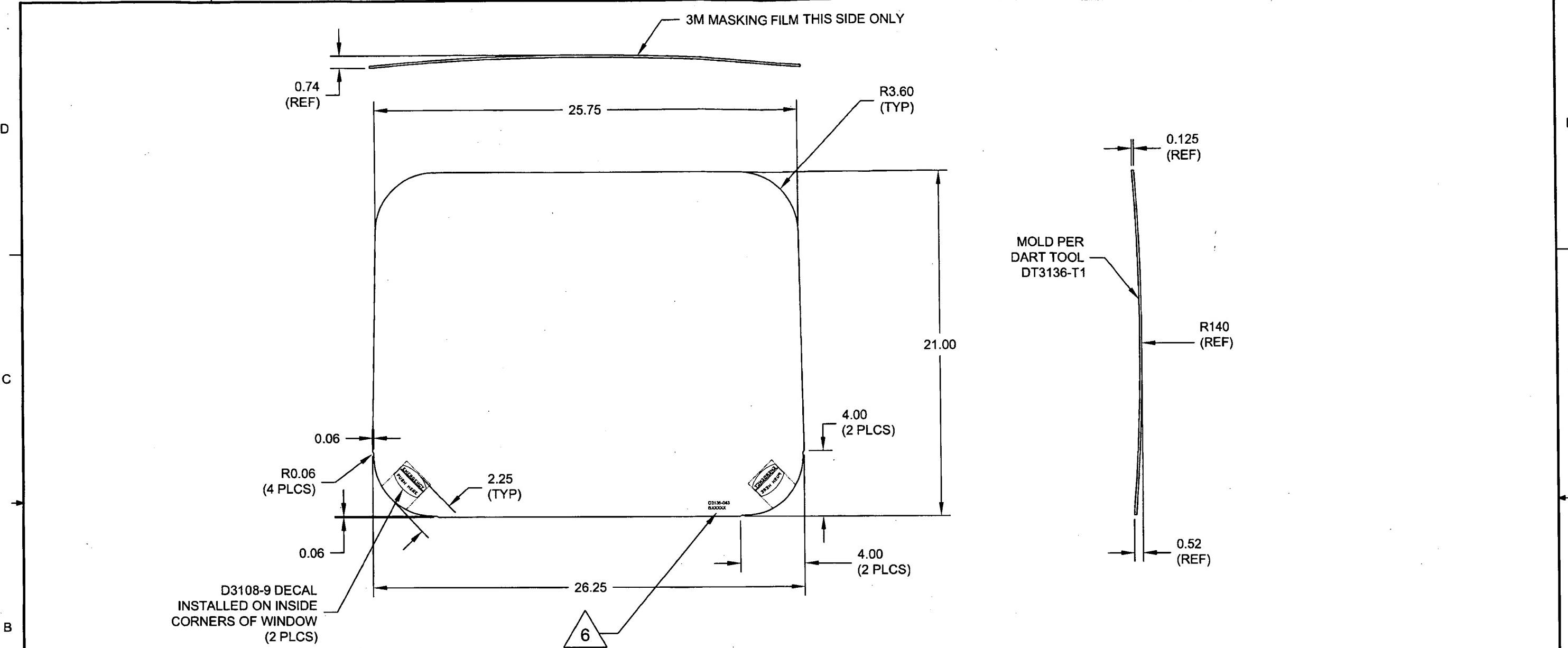
Rev	Date	Change	Revised by,	Approved
A	07.10.19	New Issue	KJ/EC/DD	

8 7 6 5 4 3 2 1



RELEASED 07.09.22 # UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 43005

8 7 6 5 4 3 2 1



**D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)**

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
07.09.22 #
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2305

DESIGN	4	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:6
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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